

Work Order ID 163497

Tuesday, June 27, 2017 1:24:01 PM

163497

Page 1

Item ID: D3794-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket Fwd
 Start Date: 6/27/2017 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 6/28/2017 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: JUN 28 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3794	Rev A								
100	FLOW WATER JET	0.01							
100									
Waterjet	Memo	0.40							
FLOW CNC Waterjet	1-Cut as per Dwg D3794 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2- Debur if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.08							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.16							
Quality Control									

(8) 06/17/07/02

(8) 06/17/07/02

(8) JUL 03 2017
 DAS
 38
 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>Flow</i>	0.00				<i>SX</i>		<i>DAS 26 9-89</i>	<i>JUL 03 2017</i>
130									
Packaging	Memo	0.08							
Packaging	LOCATION ; FP001								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.80							<i>17/7/4</i>
Quality Control									

*DAS
21
9-89**JUL 04 2017*

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, June 27, 2017 1:24:04 PM

Page 1

Work Order ID: 163497

163497

Parent Item: D3794-1

D3794-1

Parent Item Name: Gasket Fwd

Start Date: 6/27/2017

Required Date: 6/28/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	118.4269	0.5902	5.246222			

MNEO60S 063

NEOPRENE SHEET 0.063

No.110750002 NEOPRENE DURO 60+/-5 "A" 1/16" IMPORT GR PT

06/17/07/02

Location

Loc Qty

Loc Code

GA

8.2149

M131990

8.2149

MAT

31.8

M135551

31.8

MAT052

78.412

M136565

9.762

M137313

68.65

6

DQA: _____ Date: _____

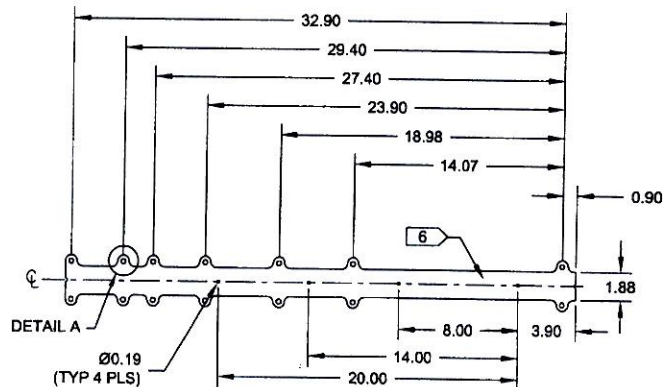


WORK ORDER NON-CONFORMANCE / UPDATE

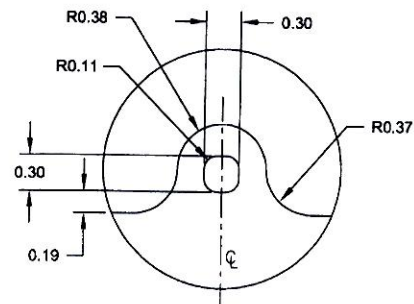
QA Closed: _____ Date: _____

Work Order update only ☐

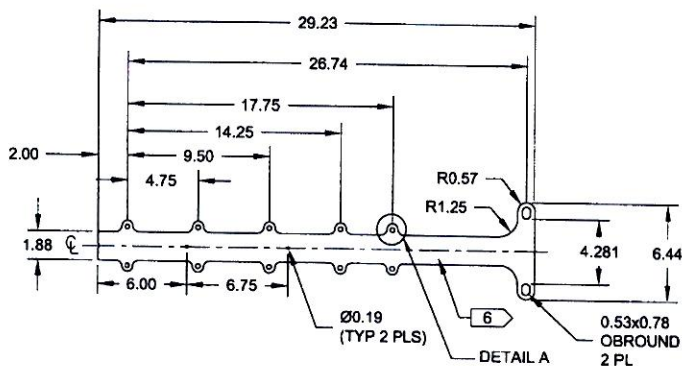
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Misidentified ☐	Past Due ☐																																																																



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163497 MJS
1700-28

RELEASED
08-05-23/11

A NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14		

DART AEROSPACE USA, INC PORT HADLOCK, WA		REV. A
DRAWING NO.	D3794	SHEET 1 OF 1
TITLE	GASKET	SCALE
		NTS

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